
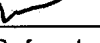


Date: Thursday, 2/8/2007 9:24:15 AM
 User: Eric Charbonneau

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 29198		
Estimate Number	: 10614		
P.O. Number	: N/A	Part Number	: D265621
This Issue	: 2/8/2007 S.O. No. : N/A	Drawing Number	: D2656 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11/3/2006 Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 29198	Material	: N/A
Written By	: 	Due Date	: 11/12/2006 Qty: 40 Um: Each
Checked & Approved By	: 		
Comment	: Est: D 02.10.25 Re-format KJ Est Rev:E Now on Waterjet 06-11-02 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1010S20GA	1010/1025/A21/6aA SHEET
-----	------------	-------------------------




Comment: Qty.: 0.5880 sf(s)/Unit Total : 23.5200 sf(s)

M1010S20GA .040"

Batch: M102684 (8)

M103069 (32)

 (for SAD)
07.02.07

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------




Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

FLOW WATER JET

1-Cut as per Dwg D2656

Dwg Rev: DProg Rev: D

2-Deburr if necessary


 07.02.07 (for SAD)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

INSPECT PARTS AS THEY COME OFF MACHINE


 07.02.07 (for SAD)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

SECOND CHECK

 07/02/07 (40)

(2)

10/10/10

10/10/10

10/10/10

10/10/10

10/10/10

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 29198

Part Number: D265621

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

BRAKE NC

NC BRAKE



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
NC BRAKE
Form bend & juggle as per Dwg D2656 using DT8261 & DT8326.

SD 07/02/09

40

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
INSPECT WORK TO CURRENT STEP

070209 (40)

7.0

POWDER COATING

POWDER COATING



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M101601

(40x)

MR/J

07/08/09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
INSPECT POWDER COAT/CHEMICAL CONVERSION

07/02/09

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PACKAGING RESOURCE #1
Identify and Stock
Location: FP21

JL 07/02/09 x40

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
FINAL INSPECTION/W/O RELEASE

07/02/09 (40)

Job Completion



U 07.02.09

Date: Monday, 10/30/2006 7:40:37 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 29198
 Estimate Number : 10614
 P.O. Number :
 This Issue : 10/30/2006 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : PURCHASED PARTS
 Previous Run : 27075
 Written By :
 Checked & Approved By : *06 10 30*
 Comment : Est: D 02.10.25 Re-format KJ

Drawing Name : WEARSHOE

Part Number : D265621
 Drawing Number : D2656 REV D
 Project Number : N/A
 Drawing Revision : D
 Material :
 Due Date : 11/12/2006

Qty: 40 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: _____

Email or ship DXF file to vendor

Laser Cut per Dwg D2656 flat pattern D2656-21

Material release note required

2.0

D265621F

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)
 Wearplate

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material release note is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2656-21T1

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/30/2006 7:40:38 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 29198

Part Number: D265621

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

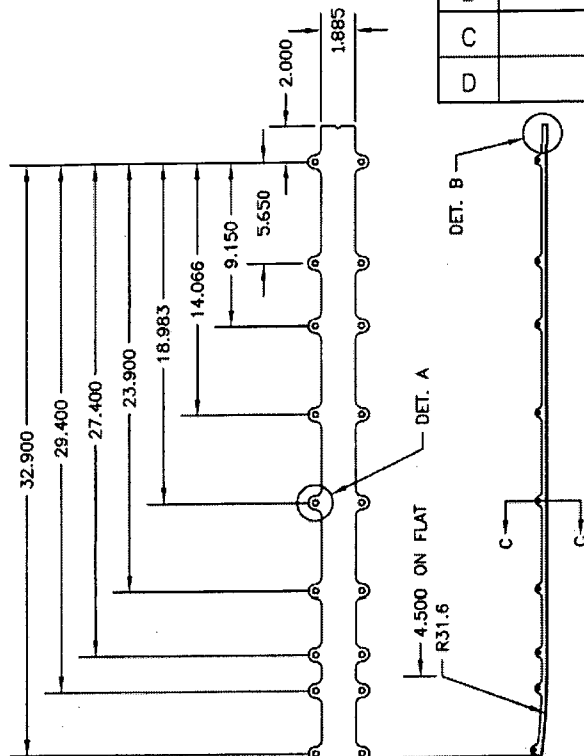
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

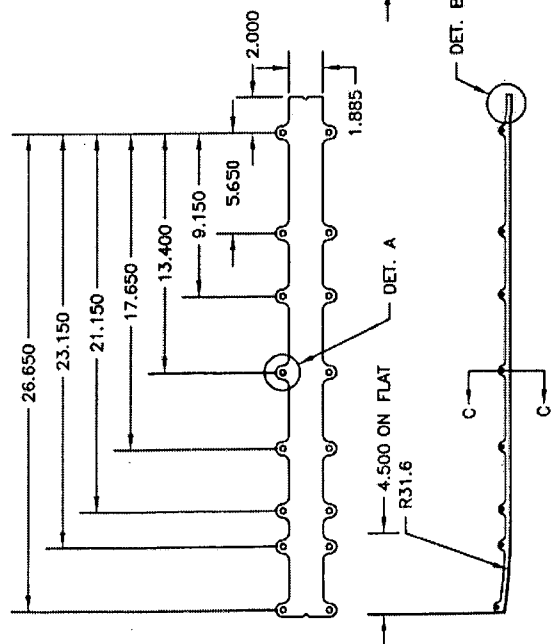


DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2656	REV. D SHEET 1 OF 4
DATE 05.08.17	TITLE WEARSHOE	SCALE 1:10	
A	97:03:25	NEW ISSUE	
B	97:06:02	CHANGED TABS	
C	97:06:26	R31.6 WAS R19.5	
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT	

D2656-13



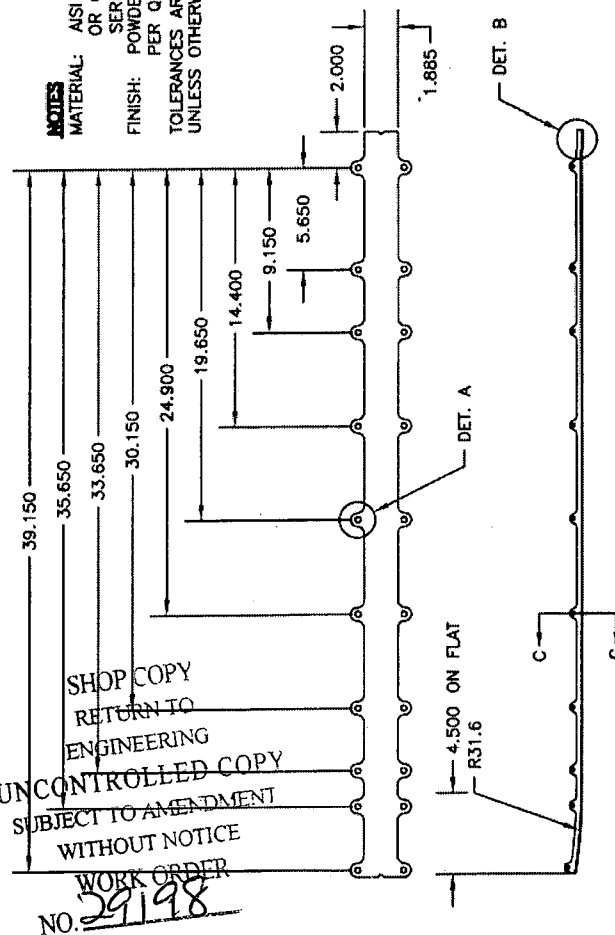
D2656-11



NOTES
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA C40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
05.09.08

D2656-15



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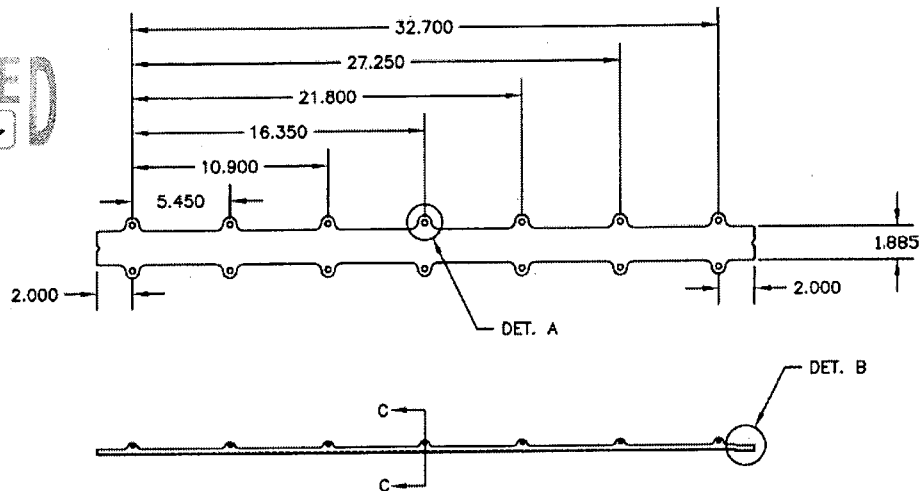
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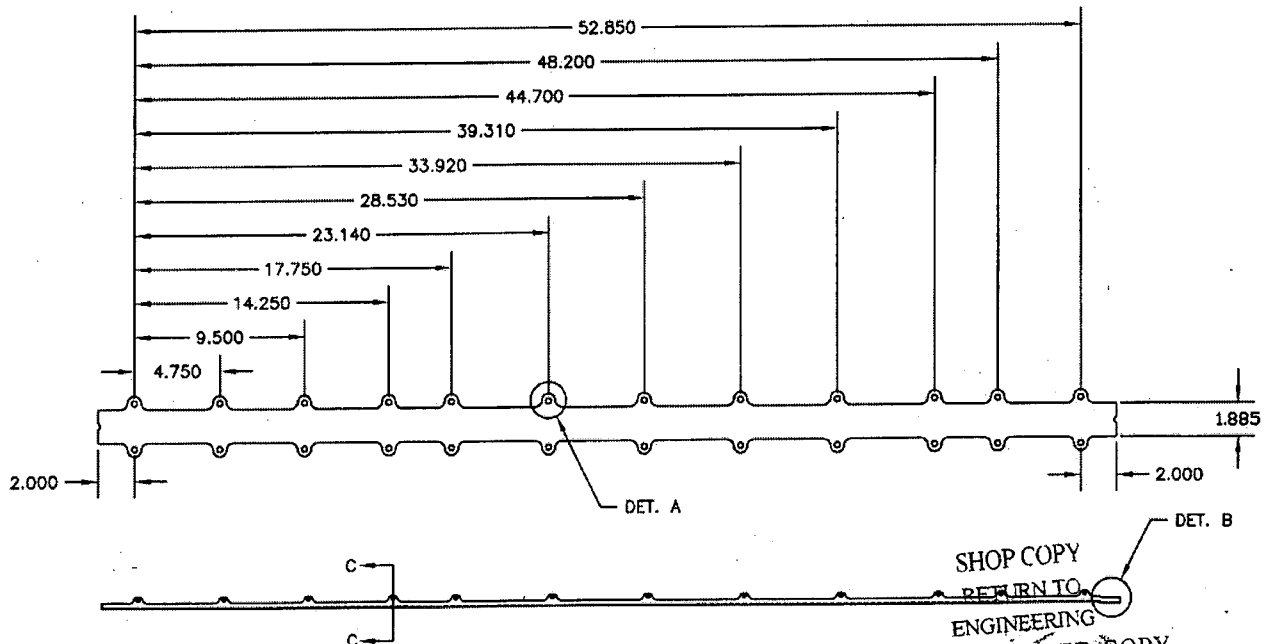
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

RELEASED
05.07.06

D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

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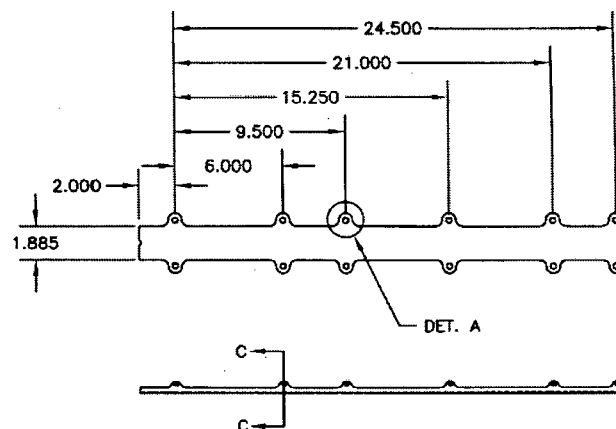
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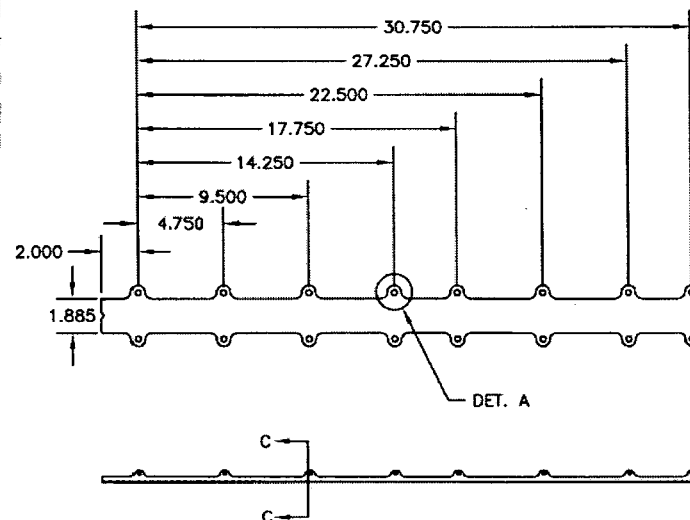


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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.08.17	DRAWING NO.	D2656	REV. D
		TITLE	WEARSHOE	SHEET 3 OF 4
		SCALE	1:10	

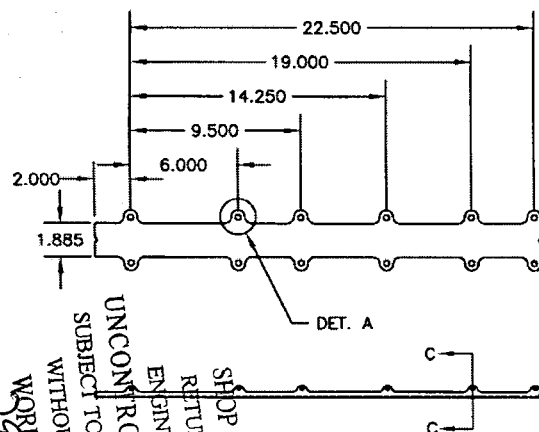
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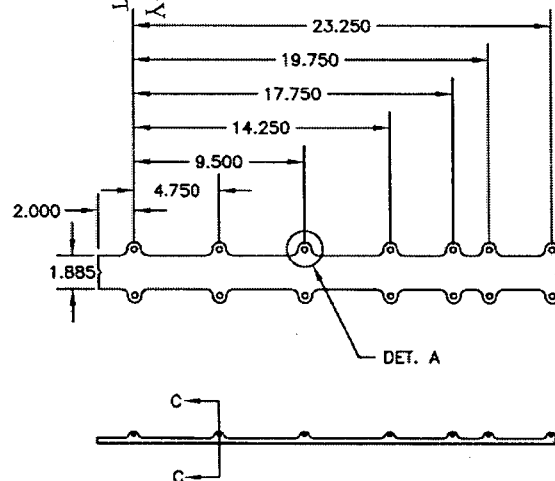
D2656-37



D2656-31



D2656-35



RELEASED
05.07.06

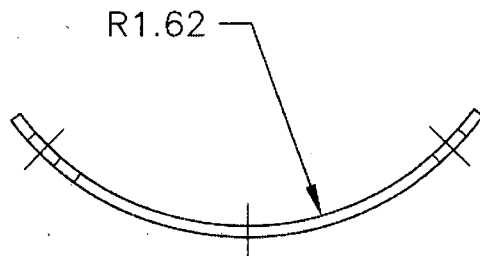
NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED



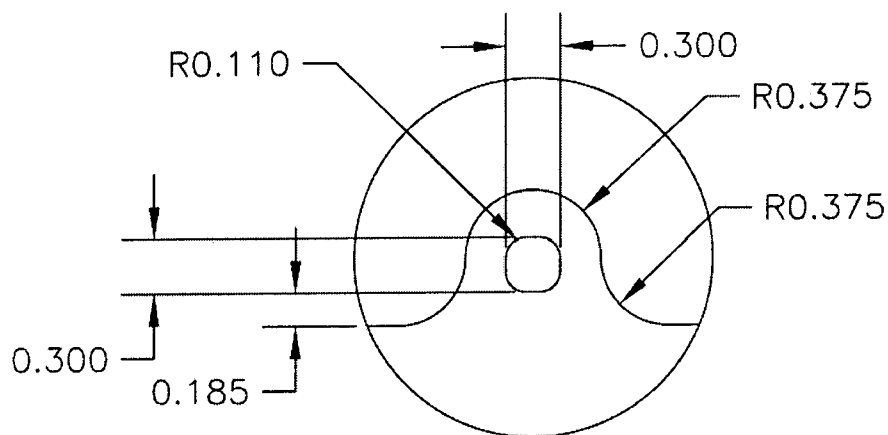
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656	REV. D SHEET 4 OF 4
DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

SECTION C-C

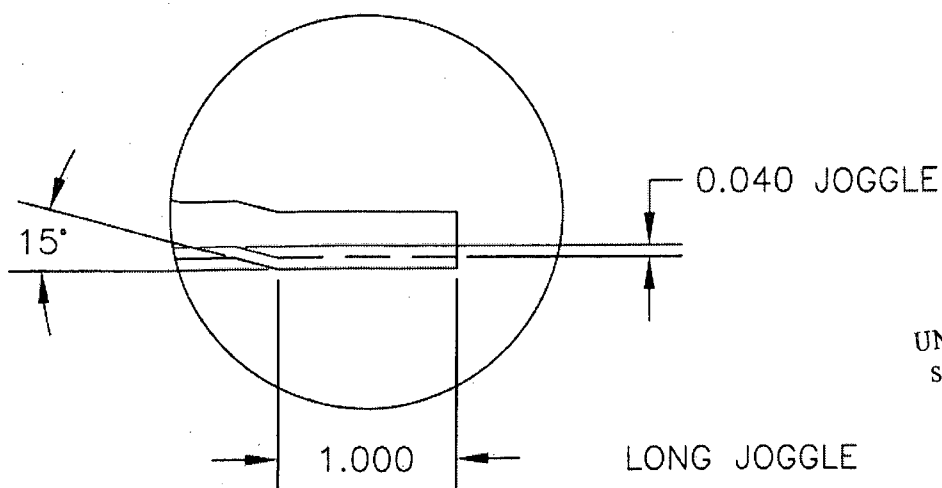


RELEASED
05.09.06

DETAIL A



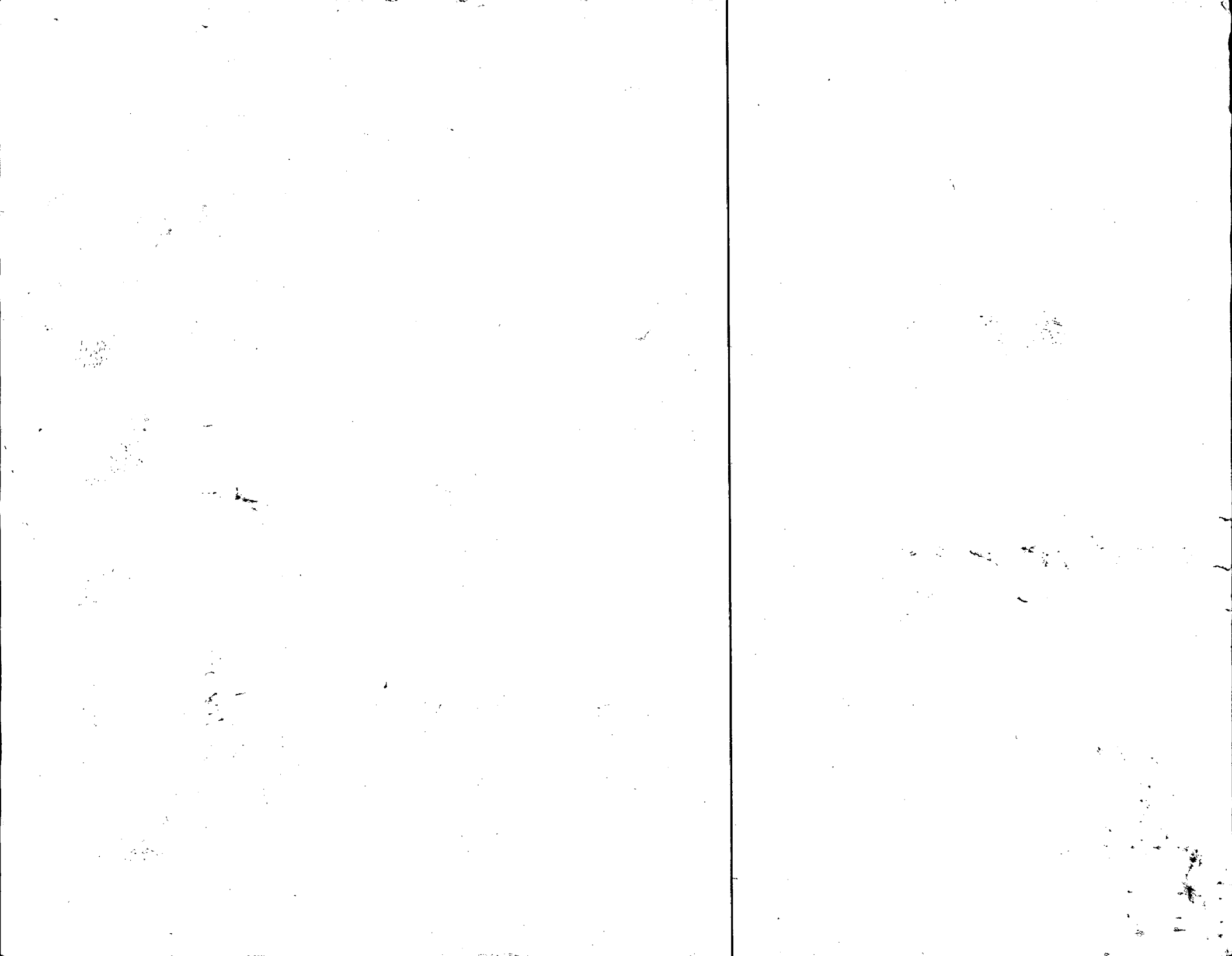
DETAIL B



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Date: Friday, 03/11/2006 7:50:49 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 29198
 Estimate Number : 10614
 P.O. Number :
 This Issue : 03/11/2006 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 29198
 Written By :
 Checked & Approved By :
 Comment : Est: D 02.10.25 Re-format - KJ
 Est Rev:E Now on Waterjet 06-11-02 JLM

Drawing Name : WEARSHOE
 Part Number : D265621
 Drawing Number : D2656 REV D
 Project Number : N/A
 Drawing Revision : D
 Material :
 Due Date : 12/11/2006 Qty: 40 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M1010S20GA

1010/1025/A21/6aA SHEET



Comment: Qty.: 0.5880 sf(s)/Unit Total: 23.5200 sf(s)

M1010S20GA .040"

X Batch: M102624 (8)

M103069 (32)

SAP

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2656

Dwg Rev: 0

Prog Rev: 0

SAP 07/02/05

2-Deburr if necessary

SAP 07/02/07

SAP

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAP 07/02/05

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SAP 07/02/07

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

